

Work Order ID 71107-2SPLT
 Wednesday, June 22, 2011 3:39:28 PM



Item ID: D2572

Revision ID:

Item Name: Saddle, Fwd In 205

Start Date: 6/23/2011 Start Qty: 12.00

Required Date: 7/7/2011 Req'd Qty: 12.00

Reference:

Approvals:

Process Plan: *MF*

QC:

Date: 11-06-22

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2572

Rev E

100

0.00



HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

Program Batch No. 71107

Double check by: B.A.

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets

2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets

3-Machine Step No 3 per Folio FA051 and insp

OK/Req 11.7.19 4 0

110

0.00



Mill Conv

Conventional Milling Machine

CONVENTIONAL MILLING MACHINE

Memo

Machine keyway as per dwg D2571 & D2572

OK/Req 11.7.19 4 0

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Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

Quality Control

130

QC8- Inspect parts - second check

0.00

QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

HandFinish

Memo

0.00

Hand Finishing

only Req 11-7-11

11-7-11

4

0

DA 11/07/21

4

0

H 0 BK 11-7-21

Work Order ID 71107



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Wednesday, June 22, 2011 3:39:29 PM

Item ID: D2572

Accept



Setup Start



Revision ID:

Item Name: Saddle, Fwd In 205

Stop



Start Date: 6/23/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 7/7/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

M 17745

0.00

H BR 11-7-21

Powder Coating

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

11:10
300
11:40

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

f φ M 11-7-21

170

Identify as per dwg & Stock Location:

0.00



Packaging

Memo

0.00

Packaging

433

11/7/22 @ 4:00

Work Order ID 71107



Page 4

Wednesday, June 22, 2011 3:39:29 PM

Item ID: D2572

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle, Fwd In 205

Start Date: 6/23/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 7/7/2011 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

189

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/7/25

11-07-22

Picklist Print

Wednesday, June 22, 2011 3:39:23 PM

Page 1

Work Order ID: 71107

Parent Item: D2572

Parent Item Name: Saddle, Fwd In 205



Start Date: 6/23/2011

Required Date: 7/7/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP: 1 02.10.02 Re-format; Change to Dwg Rev. D & incorporated
D2572 KJ

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-005		Manufactured	No			100	Each	49.0000	1	12			
Saddle Billet													

Location	Loc Qty	Loc Code
MAT045	38	
66966	18	
→ 70676	20	
MAT046	11	
65382	4	
65953	4	
66966	3	

10 *and 11/07/14*

DART AEROSPACE LTD	Work Order: 71107
Description: Saddle, Fwd Inboard	Part Number: D2572
Inspection Dwg: D2572 Rev. E	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		.441	.440	.440	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.004	8.002	8.004	8.004		
F	0.490	0.510		.502	.494	.495	.495		
G	0.257	0.262		.259	.257	.257	.257		
H	0.375	0.380		.378	.377	.377	.377		
I	0.490	0.510		.498	.500	.500	.500		
J	1.174	1.184		1.178	1.178	1.178	1.178		
K	0.558	0.578		.566	.565	.565	.565		
L	1.174	1.184		1.178	1.178	1.178	1.178		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.873	3.874	3.874	3.874		
P	0.115	0.135		.125	.124	.125	.125		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.257	.253	.252	.252		
S	0.115	0.135		.133	.132	.132	.132		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		.240	.240	.242	.242		
W	0.115	0.135		.124	.124	.124	.124		
X	0.307	0.312		.310	.311	.311	.311		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.367	.366	.366	.366		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.626	.626	.626	.626		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.250	.250	.250	.250		
AE	1.375	1.395		1.384	1.387	1.387	1.387		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.260	.260	.260	.260		
AH	0.240	0.260		.250	.250	.250	.250		
AI	2.000	2.020		2.001	2.001	2.001	2.001		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

20.02
Re. 15

4

Measured by: S.K. / R.S.
Date: 11.7.19

Audited by: B.A.
Date: 11/07/21

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD		Work Order: 71107
Description: Saddle, Fwd Inboard		Part Number: D2572
Inspection Dwg: D2572 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				5 1	6 2	7 3	8 4		
A	0.438	0.443		.440	.440	.440	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.004	8.004	8.004	8.004		
F	0.490	0.510		.495	.495	.495	.495		
G	0.257	0.262		.257	.257	.257	.257		
H	0.375	0.380		.377	.377	.377	.377		
I	0.490	0.510		.500	.500	.500	.500		
J	1.174	1.184		1.178	1.178	1.178	1.178		
K	0.558	0.578		.565	.565	.565	.565		
L	1.174	1.184		1.178	1.178	1.178	1.178		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		.125	.125	.125	.125		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.252	.252	.252	.252		
S	0.115	0.135		.132	.132	.125	.125		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		.242	.242	.242	.242		
W	0.115	0.135		.124	.124	.125	.125		
X	0.307	0.312		.311	.311	.311	.311		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.366	.366	.366	.366		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.626	.626	.628	.628		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.250	.250	.252	.252		
AE	1.375	1.395		1.387	1.387	1.387	1.387		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.260	.260	.260	.260		
AH	0.240	0.260		.250	.250	.252	.252		
AI	2.000	2.020		2.001	2.001	2.001	2.001		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

29.02

29.15
29.02

11

Measured by: RQ
Date: 11.7.19

Audited by: H.A
Date: 11/07/21

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
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DART AEROSPACE LTD		Work Order: 71107
Description: Saddle, Fwd Inboard		Part Number: D2572
Inspection Dwg: D2572 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				x 7	2 ¹⁰	3	4		
A	0.438	0.443		.440	.440				
B	1.745	1.755		1.750	1.750				
C	3.495	3.505		3.500	3.500				
D	1.745	1.755		1.750	1.750				
E	7.990	8.010		8.004	8.004				
F	0.490	0.510		.495	.495				
G	0.257	0.262		.257	.257				
H	0.375	0.380		.377	.377				
I	0.490	0.510		.500	.500				
J	1.174	1.184		1.178	1.178				
K	0.558	0.578		.565	.565				
L	1.174	1.184		1.178	1.178				
M	1.490	1.500		1.495	1.495				
N	2.495	2.505		2.500	2.500				
O	3.869	3.879		3.874	3.874				
P	0.115	0.135		.125	.125				
Q	0.115	0.135		.135	.135				
R	0.240	0.260		.252	.252				
S	0.115	0.135		.125	.125				
T	0.178	0.198		.188	.188				
U	2.940	2.980		2.960	2.960				
V	0.230	0.250		.242	.242				
W	0.115	0.135		.125	.125				
X	0.307	0.312		.311	.311				
Y	0.760	0.765		.760	.760				
Z	0.352	0.372		.366	.366				
AA	0.470	0.530		.500	.500				
AB	0.615	0.635		.628	.628				
AC	0.053	0.073		.063	.063				
AD	0.240	0.260		.252	.252				
AE	1.375	1.395		1.387	1.387				
AF	0.115	0.135		.135	.135				
AG	0.240	0.280		.260	.260				
AH	0.240	0.260		.252	.252				
AI	2.000	2.020		2.001	2.001				
AJ	0.023	0.043		.033	.033				
Accept/Reject									

Rq. 02
Rq. 15
Rq. 02

11

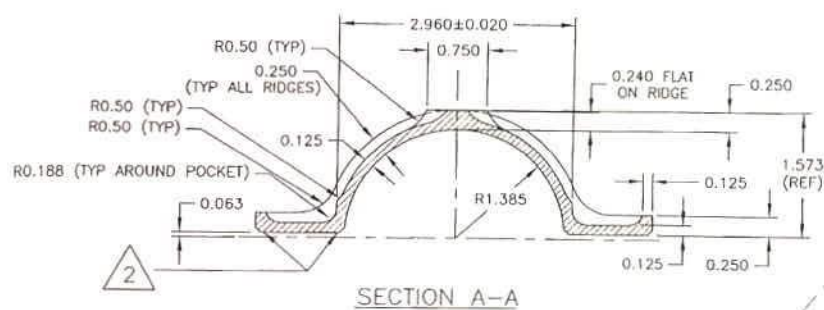
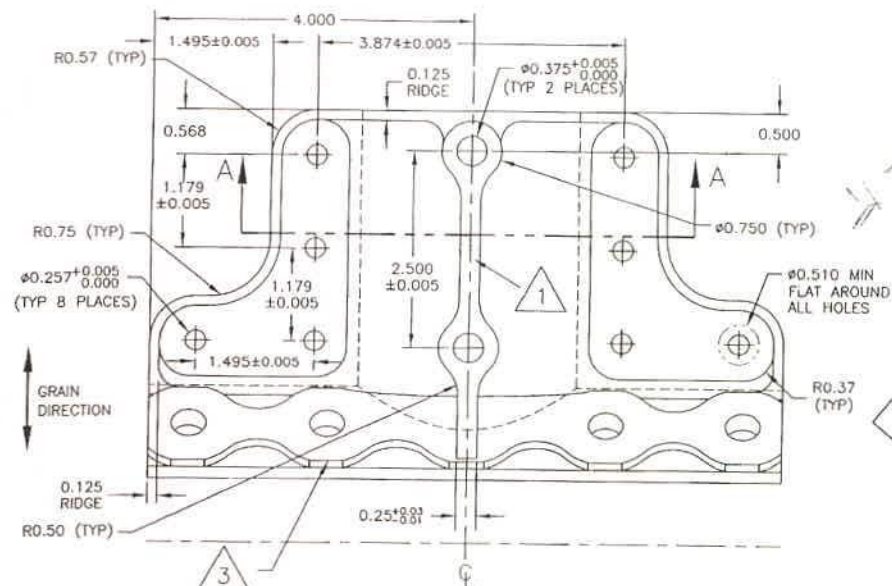
Measured by: Rq
Date: 11.7.20

Audited by: H.A
Date: 11/07/21

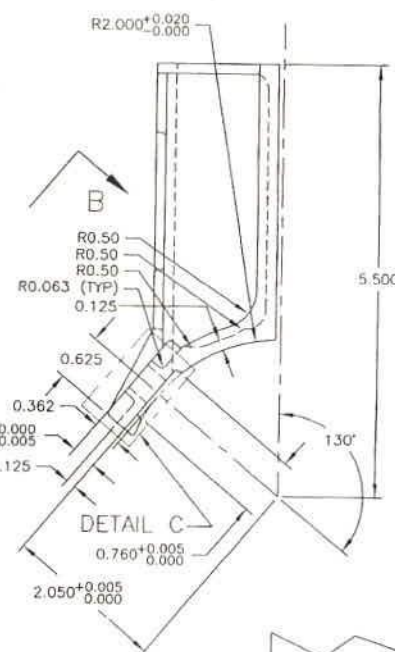
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

RELEASED

05.12.06



DETAIL C
SCALE 2:1

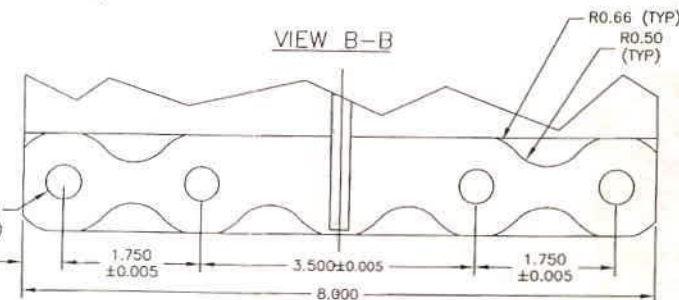


NOTES

MATERIAL: 7075-T7351 (Q0-A-250/12)
(REF DART SPEC. D6102-003)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER
DART QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
2 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
3 CHAMFER 0.063 x 45° ALL AROUND
4 CHAMFER 0.033 x 45° (SEE DETAIL C) E

VIEW B-B



E	05.07.13	ADD CHAMFER ON RIDGE NOTE 4
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE
DESIGN	DS	DRAWN BY PH
CHECKED		APPROVED
DATE	05.07.13	TITLE INNER FWD SADDLE
		DART AEROSPACE LTD. HAMPSHIRE, ONTARIO, CANADA
		DRAWING NO. D2572
		REV. E
		SHEET 1 OF 1
		SCALE 2:3

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